

Roper Whitney / No. 622 Rotary Machine

The forming machines included in this section offer a broad variety of shapes and capabilities in forming sheet metal for a combination of uses: beading, crimping, setting down, double seaming, turning, burring, wiring, elbow edging, flanging and flattening. All are precise in the job they do and are readily adaptable to job requirements. Most are portable and may be set up at the job with a clamp-on base.

The No. 622 Series is similar to the No. 544, with the addition of a 7" deep throat for additional forming capabilities, such as furnace collar edging. The Model No. 622 includes a set of rolls (A, C, D, E and F) and gauges or may be ordered without rolls as Model No. 622LR.* A number of rolls may be ordered separately from the Roll Chart on page 9 to use with this machine.

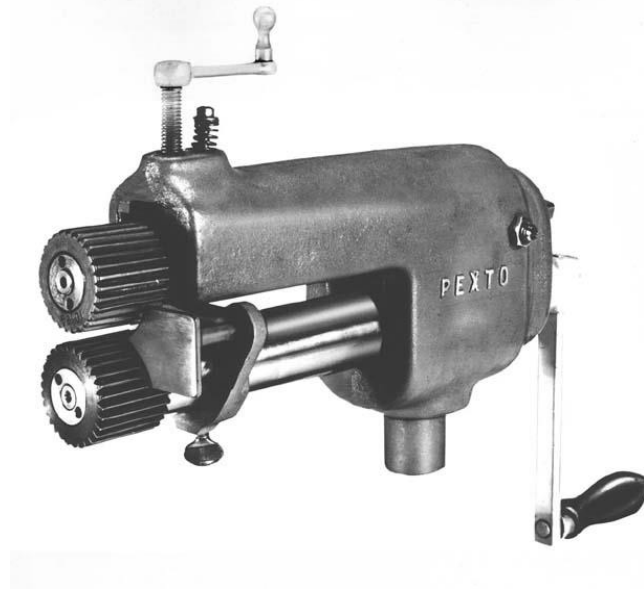
No. 622 Series machines include No. 975 clamp-on offset base.

Specifications:

| | No. 622 Ser. |
|--------------------|--------------|
| Capacity (gauge) | 24 |
| Throat Depth (In.) | 7 |

Order Guide

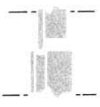


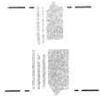




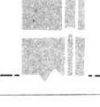
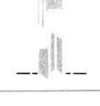

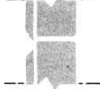
| Description | Catalog No. | Weight (lbs.) |
|--|-------------|---------------|
| No. 622LR Combination Rotary Machine without rolls. Includes throat gauges and extension gauge. | 164006220 | 45 |
| No. 622 Combination Rotary Machine with A, C, D, E, F rolls. Includes standard ext. and throat gauges. | 164006221 | 50 |
| Gauges For No. 622 Series | 259200032 | -- |
| Standard Gauge | 259700045 | -- |
| Curved Gauge | 259700060 | -- |
| Extension Gauge | 259700093 | -- |
| Throat Gauge | | |
| Rolls (see Roll Chart, page 5) | 239009750 | 11 |
| No. 975 Base | | |



Base for Forming Machines No. 975

No. 975 is a removable bench-mounted Standard Duty Offset Base.



| Roll Style | 2" Centers | | | | | | | |
|--------------|--|--|------------------------|------------------------------|------------------------|---|------------------------|------------------------|
| | Roll Description | Roll Cat. Number | | Gauge Req'd Series 544 | Gauge Req'd Series 622 | Roll Catalog No. | Gauge Required (3617) | Spacing Collar (3617) |
| A |  Turning | 1/8" | 350000001 350000002 | 259700028 | 259700032 | 3/16" | 350000086 350000087 | 259700035 381700092 |
| B | | 3/16" | 350000049 350000050 | 259700028 | 259700032 | 1/4" | 350000088 350000089 | 259700035 381700092 |
| | | | | | | 5/16" | 350000090 350000091 | 259700035 381700092 |
| C |  Burring | 350000003 350000004 | | 259700028 | 259700032 | 350000092 350000093 | 259700035 | 381700092 |
| D |  Wiring | 350000005 350000006 | | 259700028 | 259700032 | 350000094 350000095 | 259700035 | 381700092 |
| No. 1 |  Elbow Edging | 350000051 350000052 | | 259700028 or 259700046 | 259700032 | 350000122 350000123 | 259700035 | 381700092 |
| L |  Flange | 350000053 350000054 | | 259700029 | 259700045 | 350000137 350000138 | CONSULT FACTORY | 381700092 |
| M |  Flattening | 350000055 350000056 | | NONE | NONE | 350000139 350000140 | NONE | 381700092 |
| E |  Crimping | 350000007 350000008 | | N/A | 259700060 | 1/4" 350000098 350000099 5/16" 350000096 350000097 | 259700034 | 381700092 |
| F |  Ogee Bead | 3/4" | 350000009 350000010 | N/A | 259700093 | 9/16" 350000100 350000101 1" 350000011 350000012 | 259700035 | Not Req'd 381700092 |
| G |  Single Bead | 1/4" | 350000029 350000030 | N/A | 259700093 | 3/8" 350000013 350000014 5/8" 350000124 350000125 | 259700035 | 381700092 Not Req'd |
| H |  Slitting Cutters | 350700068 350700069 | | N/A | 259700032 | Carbon 350700070 (2 req'd) High Speed 350700067 (2 req'd) | 259700035 | 381700085 |
| N |  Furnace Collar Edging | 350000067 350000068 350000069 (2 req'd) | | N/A | 259700060 | 350000070 350000071 350000072 350000073 | 259700034 | 381700092 |
| P |  Offset | 350000076 350000077 | | N/A | 259700060 | 350000074 350000075 | 259700034 | 381700092 |